

Work Order ID 89763

89763

Page 1

Wednesday, September 05, 2012 10:30:56 A

Item ID: 647.0111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Panel
 Start Date: 9/5/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 9/28/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: 12-09-15 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.0100	A								

110

0.00

110

Waterjet

FLOW CNC Waterjet

2024 . 063

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

20 0 Jm 12-9-16

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

20 0 Jm 13-9-16

Work Order ID 89763***89763***

Page 2

Wednesday, September 05, 2012 10:30:56 A

Item ID: 647.0111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 9/5/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/28/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 Smb 12-9-17				20			
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	0.00 DIO: 17998 A.T.G. 0.00					CL 12/09/20	20	
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00							Puff 20 (20)

Work Order ID 89763

89763

Page 3

Wednesday, September 05, 2012 10:30:56 A

Item ID: 647.0111

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 9/5/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/28/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170		0.00							
170									
SprayPaint	Memo	0.00							
Spray Painting	PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)								
	BATCH: <u>122543</u>								
180	QC14- Inspect Spray Paint	0.00							
180									
QC	Memo	0.00							
Quality Control									

Smb
12/10/25

20

20

0

0

AS
12-11-17

DAC
12/11/20

12/11/20

comb
20

89763

Wednesday, September 05, 2012 10:30:56 A

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

20

20

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

439A

Memo

0.00

0.00

Memo

0.00

Quality Control

Ref 4/20
(20)

12/11/22 JJ

mf
12-11-21

Picklist Print

Page 1

Wednesday, September 05, 2012 10:31:00 AM

Work Order ID: 89763

89763

Parent Item: 647.0111

647 0111

Parent Item Name: Panel

Start Date: 9/5/2012

Required Date: 9/28/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

110

sf

136.5200

1.0988

~~23.13263~~

23.5

JM12-9-16

M2024T3S 063

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

136.52

119916

67.1

121197

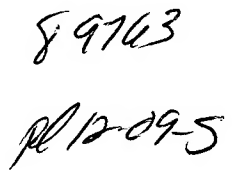
69.42

119916

~~121197~~

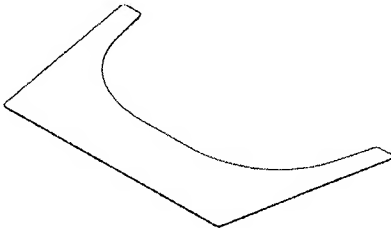
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PMZ		N/C
N/C	INITIAL RELEASE	06/28/09	P. BRAYO
A	INCORPORATED ECU 02702, 02984, 03009	04/20/11	P. BRAYO



NOTES:

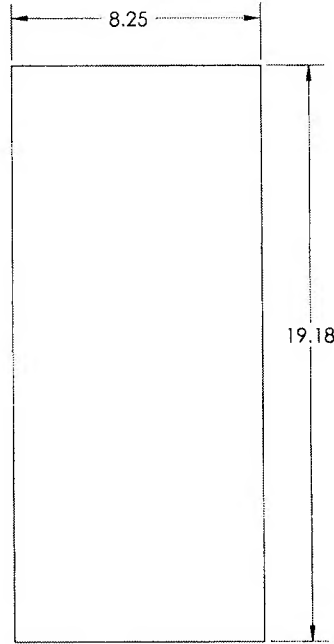
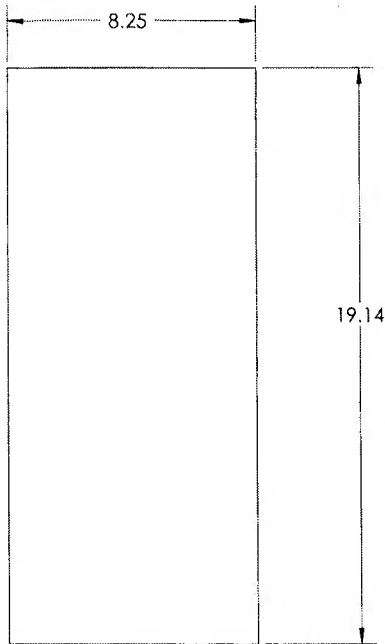
- ① MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- ② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
PRETREAT PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- ⑤ MATERIAL: 304 SS IAW AMS 5643.
- ⑥ FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



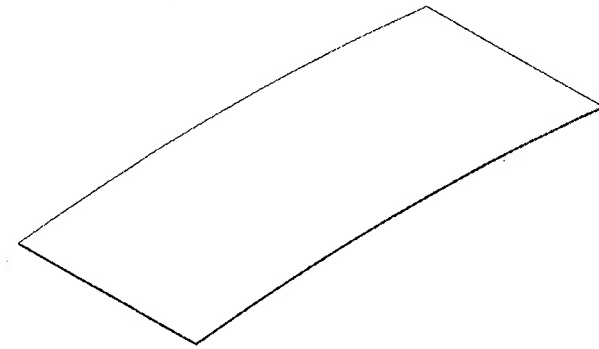
647.0110

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FLAT PATTERN



647.0111

89743



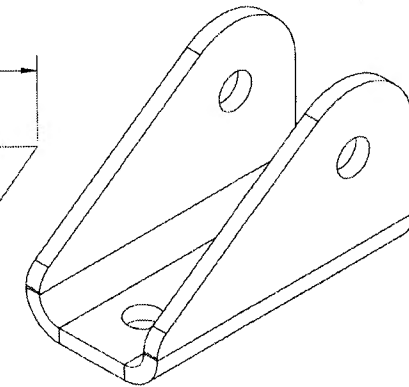
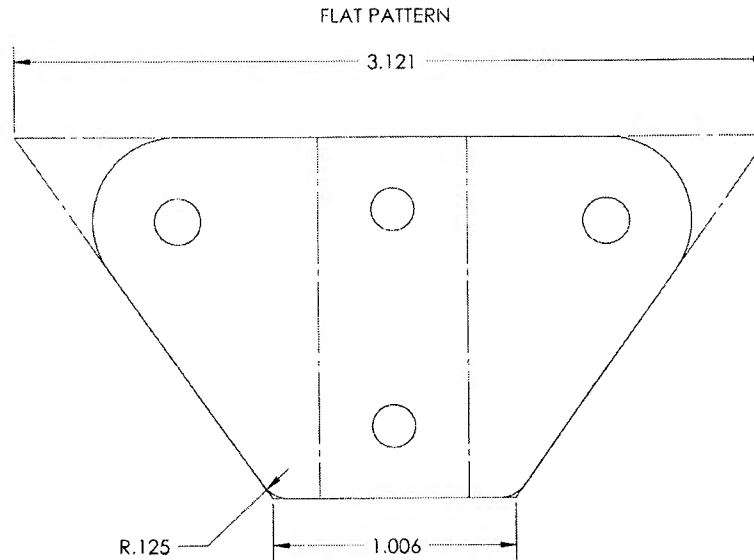
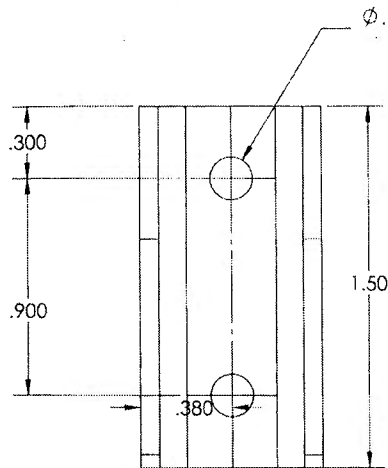
.063

R83.40

ORIGINAL DATE DWG. NO. 02-28-09		APICAL INDUSTRIES	
DRAWN BY V. POSAHO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAYVO		OCEANSIDE, CA 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAYVO		SHEETMETAL	
CONTRACT NO.		647.0100	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE CAGE CODE B 07M26	DWG. NO. 647.0100
SCALE: NONE		SHEET 2 OF 6	

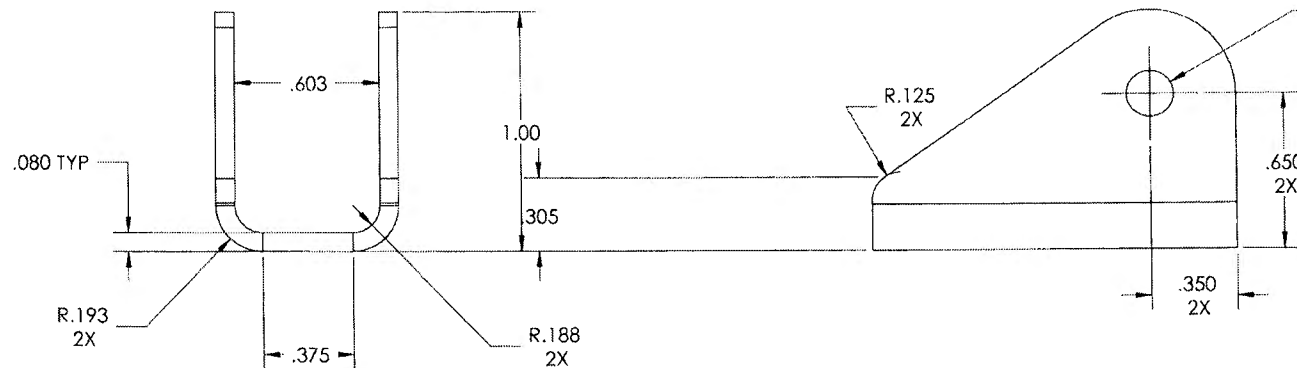
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REV.	DESCRIPTION	DATE	APPROVED



647.0112

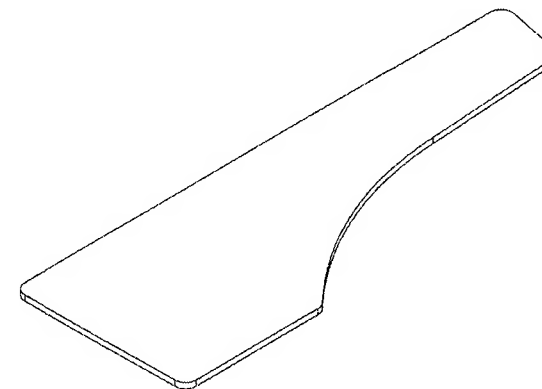
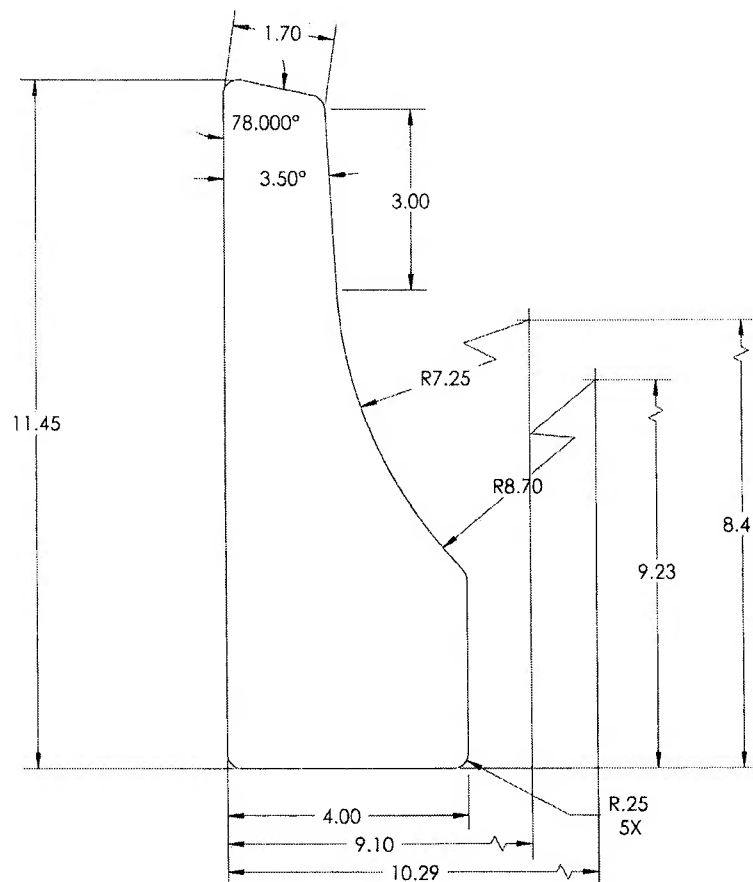
89763



ORIGINAL DATE (DD-MY-YY) 09-28-07 DRAWN BY P. BOHANNON CHECKED BY H. BRAUN APPROVED BY H. BRAUN CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.01°	SHEETMETAL SIZE / LACK CODE B / 07M26 SCALE NONE
DWG. NO. 647.0100	REV. A SHEET 3 OF 6

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REV.	DESCRIPTION	DATE	APPROVED



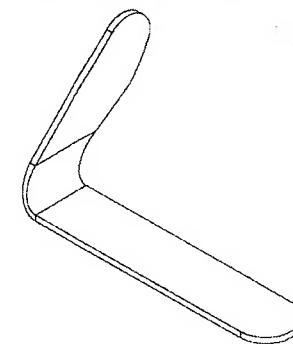
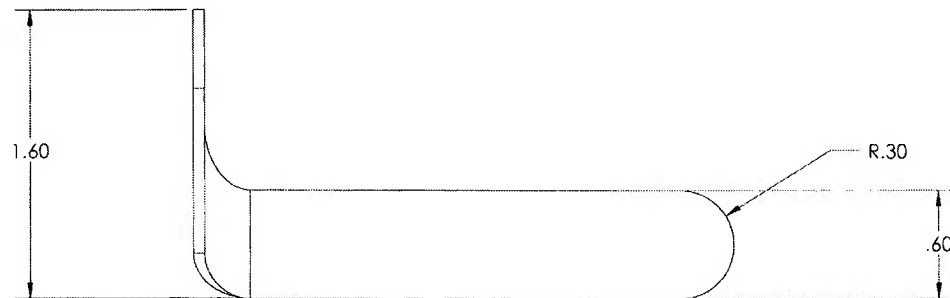
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89763

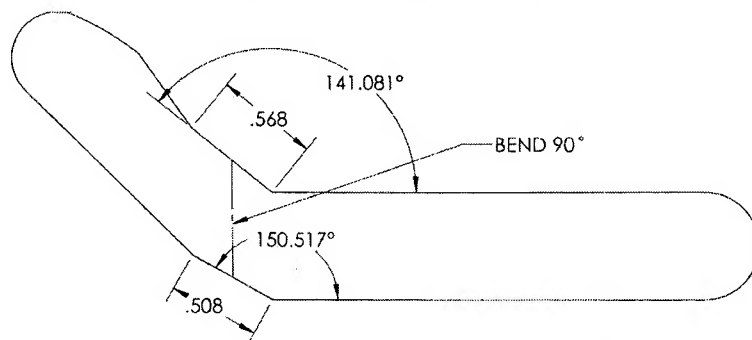
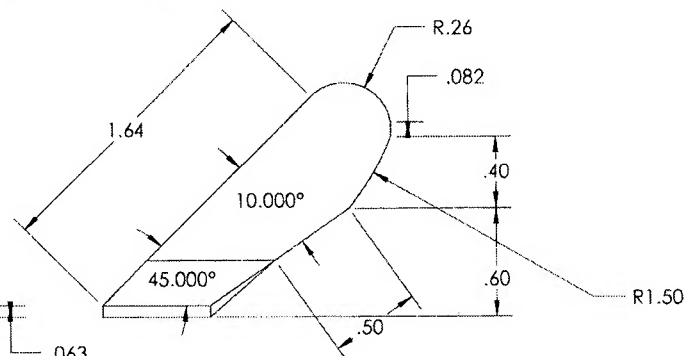
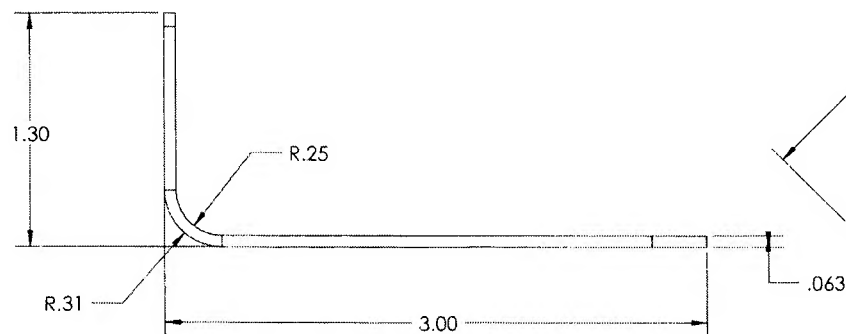
ORIGINAL DATE 05-28-07		APICAL INDUSTRIES	
DRAWN BY P. ROSANO	CHECKED P. ROSANO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. ROSANO		SHEETMETAL	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET B	REV. A
CAGE CODE 07M26		DWG. NO. 647.010J	
SCALE NONE		SHEET 4 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0114 SHOWN
647.0115 OPPOSITE



FLAT PATTERN

89143

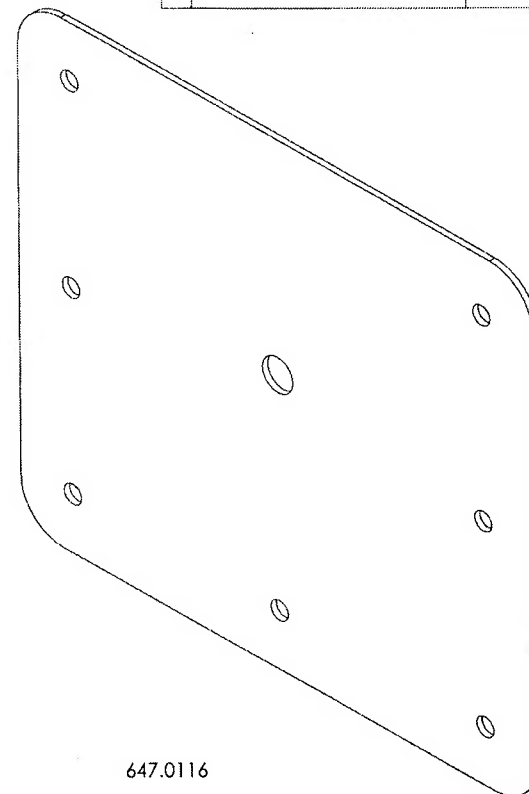
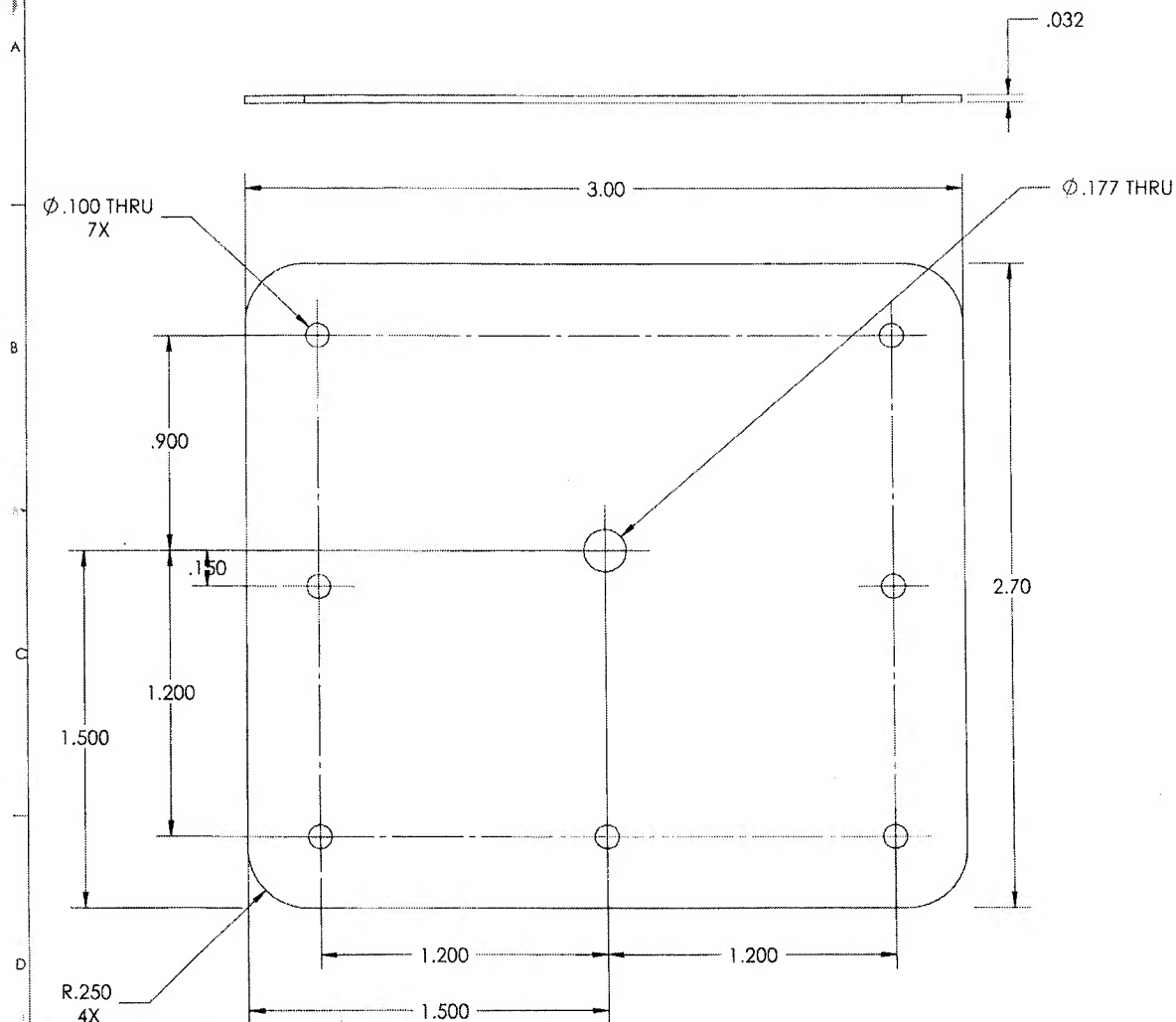
ORIGINAL DATE ENG. DATE: 1/1/01		DESIGNER P. POSANO	
DRAWN BY P. POSANO		CHECKER P. POSANO	
DRAWING APPROVAL P. POSANO		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SEE CAGE CODE B 07M26	
DWG. NO. 647.0100		REV. A	
SCALE: NONE		SHEET 5 OF 6	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

SHEETMETAL

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0116

89243

ORIGINAL DATE: 05-28-09 DRAWN BY: E. POSANO CHECKED BY: J. BRAY DRAWING APPROVAL: J. BRAY 05-28-09 CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°	SIZE: B CAGE CODE: 07M26 DWG NO: 647.0100 SCALE: NONE
	REV: A SHEET 6 OF 6



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17998

Purchase Order Date 9/26/12

PO Print Date 9/26/12

Page Number 2 of 3

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

613-446-4544

613-446-4556

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

3

90608

D4410-041 CO-PILOT
COLLECTIVE HEAD

9/28/12

1.00

Dart Truck

\$27.5000

\$27.50

Yes

Special Inst:

BLACK ANODIZE AS PER DWG D4410
REV. PB10
B90608

ANODIZE PER MIL-A-8625F TYPE I OR
IB OR IC
OR II OR IIB CLASS 2

4

89703

647.0110 ROOF
DOUBLER

9/28/12

20.00 Dart Truck

\$5.5000

\$110.00

Yes

Special Inst:

BLACK ANODIZE AS PER DWG 647.0110
REV.A
B89703

FINISH; HARD ANODIZE IAW MIL-A-
8625 TYPE III, CLASS 2,
COLOR BLACK

89763

647.0111 PANEL

9/28/12

20.00 Dart Truck

\$5.5000

\$110.00

Yes

Special Inst:

BLACK ANODIZE AS PER DWG 647.0111
REV.A
B89763

FINISH; HARD ANODIZE IAW MIL-A-
8625 TYPE III, CLASS 2,
COLOR BLACK

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO

Change Nbr: 1

Change Date: 9/26/12



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62000

Date: 24-Oct-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 20 PCS 647.0110 20 PCS 647.0111 40 PCS 647.0116 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120646	Rev:	Line:
PO: PO17998			
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <u>24/10/12</u> CERTIFIED SIGNATURE: <u></u> RECEIVER SIGNATURE: _____			